

Rush

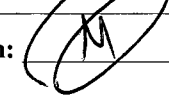
Work Order ID 124562

Monday, September 15, 2014 12:53:45 PM

124562

Page 1

Item ID: D3138-2 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Cover
Start Date: 9/17/14 Start Qty: 4.00 *4* Cust Item ID:
Required Date: 9/19/14 Req'd Qty: 4.00 *4* Customer:
Reference:

Approvals: Process Plan:  Date: 14-9-15 Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3138	Rev C								

100 FLOW WATER JET 0.00
100
Waterjet Memo 0.00
FLOW CNC Waterjet 1-Cut as per Dwg D3138
Dwg Rev: C
Prog Rev: C
2-Deburr if necessary
② 14/09/17 DAS 23 9-89

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
QC Memo 0.00
Quality Control
② 14/09/17 DAS 23 9-89

120 QC8- Inspect parts - second check 0.00
120
QC Memo 0.00
Quality Control
2 14-9-12 DAS 38 9-89

Monday, September 15, 2014 12:53:45 PM

Page 2

Hand Finishing

9-89 14-9-25

Work Order ID 124562

Monday, September 15, 2014 12:53:45 PM

Page 3

Post!
Accept
124562

Item ID: D3138-2

Revision ID:

Item Name: Cover

Start Date: 9/17/14

Start Qty: 4.00

4

Required Date: 9/19/14

Req'd Qty: 4.00

4

Reference:

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

160

Powdercoat

Powder Coating

Memo

START TIME: 8:05OVEN TEMPERATURE: 320°FINISH TIME: 8:25

0.00

2 14-9-26 DAS 34 9:09

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

(2) 14-9-26 DAS 38 9:09

180

Identify as per dwg & Stock Location: ST198

0.00

180

Packaging

Packaging

Memo

0.00

2x 14-9-26 P

Work Order ID 124562***124562***

Page 4

Monday, September 15, 2014 12:53:45 PM

Item ID: D3138-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cover

Start Date: 9/17/14

Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/19/14

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21 - Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MCS 14-09-29

ME
14-9-26

Pieklis Print

Monday, September 15, 2014 12:53:50 PM

Page 1

Work Order ID: 124562

124562

Parent Item: D3138-2

D3138-2

Parent Item Name: Cover

Start Date: 9/17/14

Required Date: 9/19/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: B04.11.29Made by Laser CutKJ/RF
IPP Rev: C 05.12.13Added level 5 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.032

Purchased

No

sf

194.1413

8

M2024T3S 032

2024-T3 .032 sheet

Dec 14 / 09 / 17

**DAS
23
9-89**

Location

Loc Qty

Loc Code

MAT022

194.1413

121309

7

123574

10.8949

124987

10

M127668

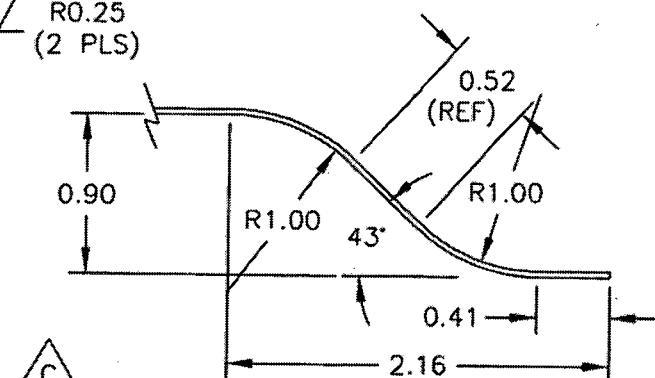
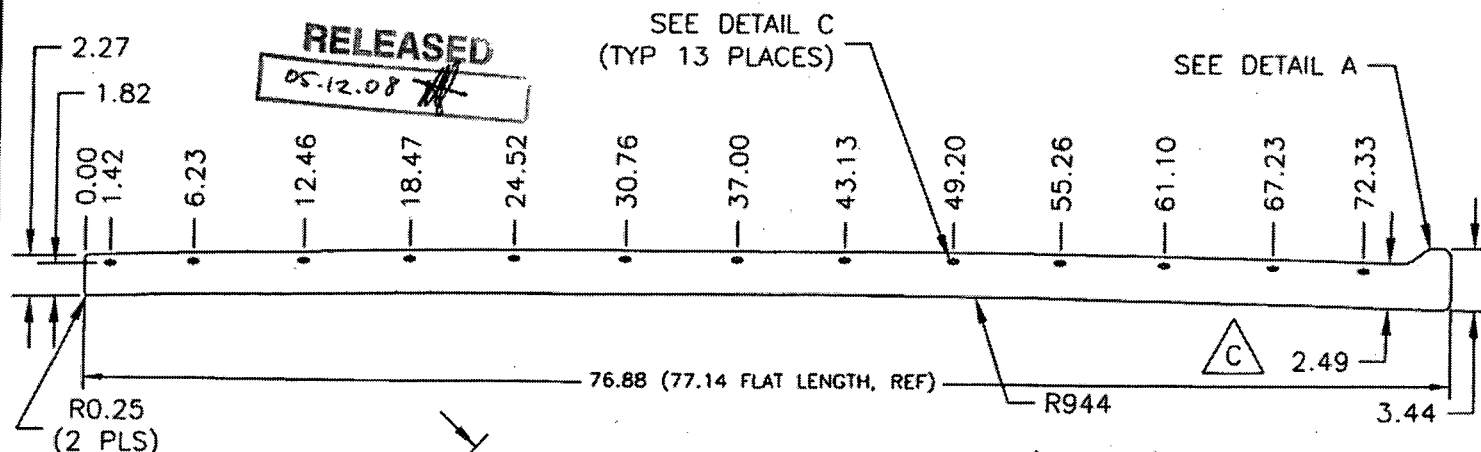
166.2464

6

DART

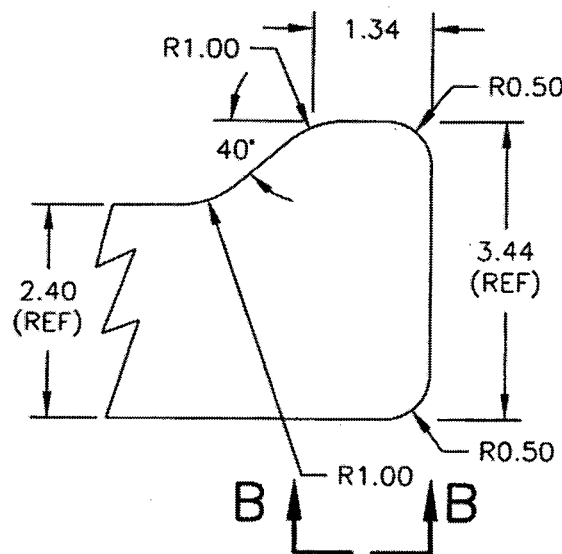
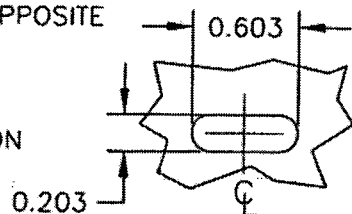
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DESIGN	CP	DRAWN BY	RF	DRAWING NO.	REV. C
CHECKED		APPROVED		D3138	SHEET 1 OF 1
DATE	05.12.05	TITLE	COVER	SCALE	1:10
A	02.04.18	NEW ISSUE			
B	04.09.20	RE-DESIGN			
C	05.12.05	CORRECT VIEW B-B; ADD 2.49 DIM.			



VIEW B-B
BEND D3138-1 AS SHOWN
BEND D3138-2 OPPOSITE
SCALE 1:1

DETAIL C
LOCATION DIMENSION
TO CENTERLINE
SCALE 1:1



DETAIL A
FLAT PATTERN SHOWN
SCALE 1:2

D3138-1 COVER (SHOWN, REPLACES PREMIER P/N B30-23000-205)

D3138-2 COVER (BEND OPPOSITE, REPLACES PREMIER P/N B30-23000-206)

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

14-9-6
124562